Work Order ID 102693 Page 1 Tuesday, June 11, 2013 8:58:52 AM Item ID: D3121-241 Accept *N900040100* Setup Start **Revision ID:** Item Name: Bearing Assembly **Start Date:** 6/11/2013 **Start Qty: 60.00** *60* **Cust Item ID: Required Date: 6/12/2013** Req'd Qty: 60.00 *60* **Customer:** Reference: Run Date: 13-6-11 Tooling: **Process Plan:** Approvals: Stop OC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan . Accept Reject Reject Insp. Work Center ID **Description Run Hours** Qty Qty Code Number Stamp **Draw Nbr Revision Nbr** D3121 Rev E 130 0.00 Small Fab *120* Small Fab 0.00 Memo Small Fab 1-Press D3121-23 Bearing into D3121-25 Cap as per Dwg D3121 140 QC5- Inspect part completeness to step on W/O *140* OC Memo Quality Control 150 Identify as per dwg & Stock Location: 5T 235 0.00 60x / 17.10. 13-06-11 *150* Packaging 0.00 Memo

Packaging

DQA: Date:					- ΔΛĎΤ											
QA Closed:		Date:			WORK ORDER NON-CONFORMANCE / UPDATE Work Order update only											
LA Closed.		Date.				Work Order apaate only										
Work Orde	er:				DISPOSITION				/PROCESS							
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Part N	lo.				Scrap	1		Machining	Small Fab	-	Pro	Quality				
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	Bending				Bend		Folio/P	rogram			Outside Dim	ensions	F	Pressure/Forced		
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ļ			-	Contamination		4	ions Incomplete/U	Jnclear		Part Moved		\	Wrong Stock Pulled			
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ļ	Inspection	٠.	Tube		Drawing		Misread	I								
	Marks/Ch	natter			Drill Holes		Off-set									
	Turning S	equence			Finish		Out of C	Calibration								
	Wave/Tw	ist in Tub)e		Fit/Function		Out of S	Sequence								

Work Center ID 160

Operation Description

QC21- Final Inspection - Work Order Release

0.00

Set Up/ **Run Hours** Tool ID

Tool # Plan Code

Accept Qty Qty

Reject Reject Number

Insp. Stamp

Page 2

160

Quality Control

QC

Memo

0.00

MLJ 13-06-12

DQA: Date:					–											
QA Closed:		Date:			WORK ORDER NON-CONFORMANCE / UPDATE Work Order update only											
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					Broken/Damage/Defect		Hardwa	re			Part Incorred	ct [Temperat	ure/Cure		
	Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	on Incomplete/Ur	nqualified		Part Lost/Mi	ssing	Weld			
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				Countersink		Misalig	ned/off center			Positioned V	Vrong	_				
	Heat Treat				Cut Too Short		Mislabe	led			Power Loss/	Surge	Other			
	Inspection	n Strip in	Tube		Drawing		Misread	I								
	Marks/Ch	natter			Drill Holes		Off-set									
	Turning S	equence			Finish		Out of 0	Calibration								
ſ	Wave/Tw	ist in Tub	oe .		Fit/Function											

Picklist Print

Tuesday, June 11, 2013 8:58:51 AM

Work Order ID:

102693

Parent Item:

D3121-241

Parent Item Name:

Bearing Assembly

Start Date: 6/11/2013

Required Date: 6/12/2013

Start Qty: 60.00

Required Qty: 60.00

Comments:

IPP Rev:A04.02.18New issueKJ/DS

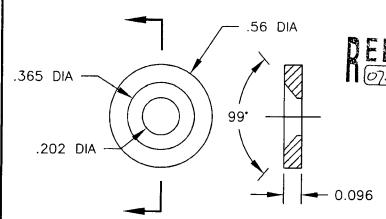
IPP Rev:B ECN 1060 07-11-12 DD verified by:E

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issue <i>f</i> i	Status
D3121-25 Cap		Manufactured	No		• •	<u></u> .	Each	90.0000	_	60		3/00	. 111
•					340	90 60	<u>L</u>	oc Code	29	- la .		1	
D3121-23 Bearing		Manufactured	No	979	05	130	Each	126.0000	<u></u>	60	B	1306) (1
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				667. 750 990	34 84	10							•

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Part N	No.				Scrap				Machining Small Fab			d. Eng. Coor.	7	Quality	ı
					Use-as-is			moforming Finishing		${f -}$		re/Packaging	┨.	Other	ı
NCR N	No.				Suspected Unapproved		Large Fab Compos			_	·	Supplier	٦		ı
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Ī	Bending				Bend		Folio/P	rogram	ſ		Outside Dime	ensions	P	ressure/Forced	
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	Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing				Broken/Damage/Defect		Hardwa	re		F	art Incorrec	t [Т	emperature/Cure	
					Burrs		Inspect	ion Incomplete/Und	qualified	P	Part Lost/Mi	ssing	v	Veld	
-					Contamination		Instruct	ions Incomplete/U	nclear	P	art Moved		v	Vrong Stock Pulled	ı
					Countersink		Misalig	ned/off center			ositioned W	/rong _			ı
	Heat Tre				Cut Too Short	-	Mislabe		Į	P	ower Loss/S	Surge	0	ther	ĺ
	_	on Strip in	Tube		Drawing	_	Misread	t		_					
:	Marks/C				Drill Holes	-	Off-set			_					
	_	Sequence			Finish		1	Calibration						· · · · · · · · · · · · · · · · · · ·	l
	ا Wave/Tı	wist in Tub	oe -	- 1	Fit/Function	1	IOut of 9	Sequence							i

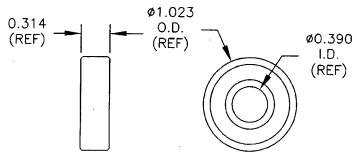


DESIGN	DRAWN BY		OSPACE LTD ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3121	REV. E SHEET 10 OF 10
DATE		TITLE	SCALE
07.11.07		BRACKET ASSEMBLY	1:1



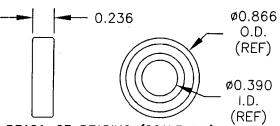
D3121-17 WASHER (SCALE 2:1)

- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



D3121-19 BEARING (SCALE 1:1)

- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES



D3121-23 BEARING (SCALE 1:1)

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES

D3121-21 BOLT (SCALE 1:1)

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE

0.375 -

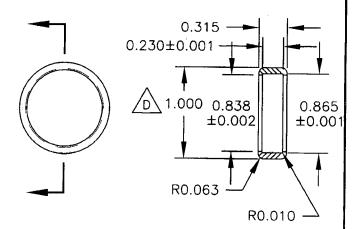
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

0.080

TAP 10-32 UNF-3A

0.050 TO 0.060

- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

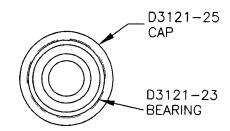


D3121-25 CAP (SCALE 1:1)

1) MATERIAL: DELRIN ROD, Ø1.25

(REF DART SPEC. M-DELRIN-R1.250)

- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES



D3121-241 BEARING ASSEBLY (SCALE 1:1)

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DQA: Date:																
QA Closed:		Date:			WORK ORDER NON-CONFORMANCE / UPDATE Work Order update only											
Work Orde	r·				DISPOSITION		AGAINST DEPARTMENT/PROCESS									
Part No. NCR No.					Rework Scrap Use-as-is Suspected Unapproved			Skid-tube Crosstube Machining Small Fal noforming Finishing Large Fab Composite		4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other				
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